



Dart Aerospace Ltd.
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RBIR7028
Job Sheet 190848



Part No: RBIR7028

Job Qty: 2 pcs

Part Name: Swashplate Bearing Install and Removal Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/19/19

Job Tracking No:

Due Date: 2/27/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG RBIR7### Rev. 0 IPP Rev. A 18.06.04 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	2 pcs	2/27/19		0.00	0.00	Small Fab - 1		
							Small Fab - 2		MLC
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	2 pcs	2/27/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		DAS FEB 27 2019 58
							QC 5 - 9		9-89
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	2 pcs	2/27/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		

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Container No: S154585



Part: RBIR7028

Job No: 190848

Serial No/Batch: S154585

Revision: 0

Inspector:

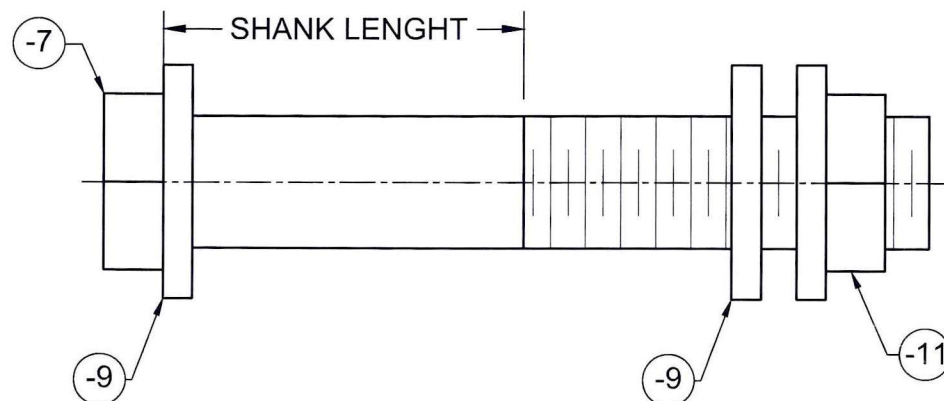
Exp Date:

Instructions:

Date: 02/19/19

				Packaging 3 - 8 - B4B					
				Packaging 3 - 9 - B4B					
				Packaging 3 - 10 - B4B					
				Packaging 3 - 11 - B4B					
				Packaging 3 - 12 - B4B					
				Packaging 3 - 13 - B4B					
				Packaging 3 - 14 - B4B					
				Packaging 3 - 15 - B4B					
				Packaging 3 - 16 - B4B					
				Packaging 3 - 17 - B4B					
				Packaging 3 - 18 - B4B					
				Packaging 3 - 19 - B4B					
				Packaging 3 - 20 - B4B					
				Packaging 3 - 21 - B4B					
				Packaging 3 - 22 - B4B					
				Packaging 3 - 23 - B4B					
				Packaging 3 - 24 - B4B					
				Packaging 3 - 25 - B4B					
				Packaging 3 - 26 - B4B					
				Packaging 3 - 27 - B4B					
				Packaging 3 - 28 - B4B					
				Packaging 3 - 29 - B4B					
				Packaging 3 - 30 - B4B					
				Packaging 3 - 31 - B4B					
				Packaging 3 - 32 - B4B					
				Packaging 3 - 33 - B4B					
				Packaging 3 - 34 - B4B					
				Packaging 3 - 35 - B4B					
				Packaging 3 - 36 - B4B					
				140 QC 21 - SA	2 pcs	2/27/19	0.00 0.00	QC 21 - SA - 21	DAS 21 3-55
								QC 21 - SA - 70	
								QC 21 - SA - 53	
				Part Op 110 - (Small Fab) 1-Assemble as per DWG. Descriptions: 120 - (QC5- Inspect part completeness to step on W/O) 130 - Identify as per dwg & Stock Location: _____ 140 - (QC21- Final Inspection - Work Order Release)					
				Job BOM					
				Part / Item	Component Name	Quantity	Operation	Container	
				90477A030	Rotating Flange Nut	2 Ea (1 ea)	110-Small Fab - 1	5079292	
92865A597	Medium-Strength Grade 5 Steel Hex Head Screw	2 Ea (1 ea)	110-Small Fab - 1	5079293					
97416A123	Black-Oxide Steel SAE Washer	4 Ea (2 ea)	110-Small Fab - 1	5079294					
RBIR7028-1	Receiver	2 pcs (1 ea)	110-Small Fab - 1	5099916					
RBIR7028-3	Remover / Installer	2 pcs (1 ea)	110-Small Fab - 1	5097380					
RBIR7028-5	Alignment Seat	2 pcs (1 ea)	110-Small Fab - 1	5099917					
Job Allocations									
Operation	Component Part	Required	Inventory	Allocated					
110-Small Fab - 1	90477A030	2	6	0					
	92865A597	2	6	0					
	97416A123	4	92	0					
	RBIR7028-1	2	2	0					
	RBIR7028-3	2	4	0					
	RBIR7028-5	2	2	0					
Part Specifications									
Specifications could not be found.									

REVISIONS		DATE	INITIAL	APPROVED
REV	DESCRIPTION			
-	-	-	-	



RED BARN MACHINE TITLE PORTABLE BEARING INSTALL & REMOVAL TOOLS; HARDWARE DWG NO. CHARTED TOOL No. -7, 9, & 11 REV - UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS XXX ± .005 XX ± .01 X ± .1 FRACTIONS ± 1/32 ANGLES ± 5° UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING SCALE NTS DATE 10-22-10 SHEET 5 of 5 DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC ALL BLACK OXIDE USED ON BEARING									
		-7 HEX HEAD CAP SCREW (QTY. 1)		-9 MACH. WASHER		-11 NUT (QTY. 1)			
TOOL #	BRG. ID.	SCREW SIZE	SHANK LENGTH	MAT.	QTY.	TYPE	TYPE		
KIR4103-7	.3125	5/16-18 UNC x 3-3/8	3/4 or less	GR. 8	2	Ø5/16 ID.	5/16-18 UNC SW. FLG. NUT MCMaster-CAR #90477A030		